

Date: Wednesday, 2/20/2008 4:23:23 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HI-SKI STEP LEG
Job Number : 37543	
Estimate Number : 11833	
P.O. Number :	Part Number : D2499
This Issue : 2/20/2008 S.O. No. :	Drawing Number : D2499 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 27501	Material :
Written By :	Due Date : 3/10/2008 Qty: 20 Um: Each
Checked & Approved By : <u>1808 02 21</u>	
Comment : Est. A 00.06.26 Removed P/O for powder coat EC	
Est. C Rev C dwg 07-09-25 DD verified by EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X04000	6061-T6 Bar 1.0" x 4.0"
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Comment: Qty.: 1.9906 f(s)/Unit Total : 39.8118 f(s)
 6061-T6 Bar 1.0" x 4.0"

Material: M6061-T6 aluminium bar 4.00"x 1.00" Thick

Batch: M106348

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 8.500" x 4.000"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio D2499
 Deburr

H.A./JML 08/03/17
J.H.

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A./JML 08/03/17

08/03/17

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

[Signature]

08/03/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/03/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-SKI STEP LEG

Job Number: 37543

Part Number: D2499

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1.



(20)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FX 08/03/17

7.0

POWDER COATING

POWDER COATING



M 107005

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*****mask slot as per dwg*****

BR 08-03-18

(20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-18

(X26)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 98

8/3/18

SC

(20x)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/19

Job Completion



m 2008/3/18

(20)

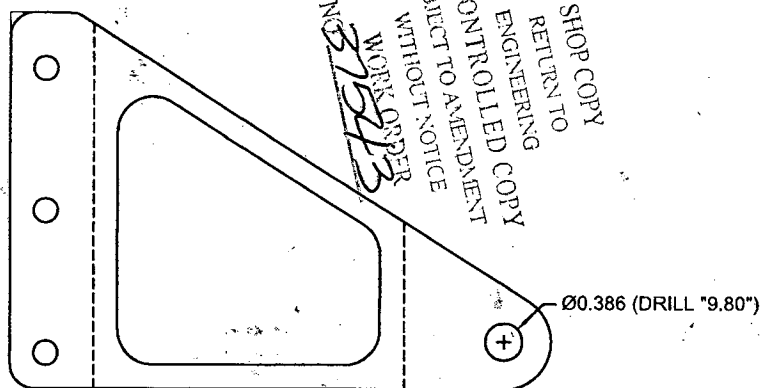
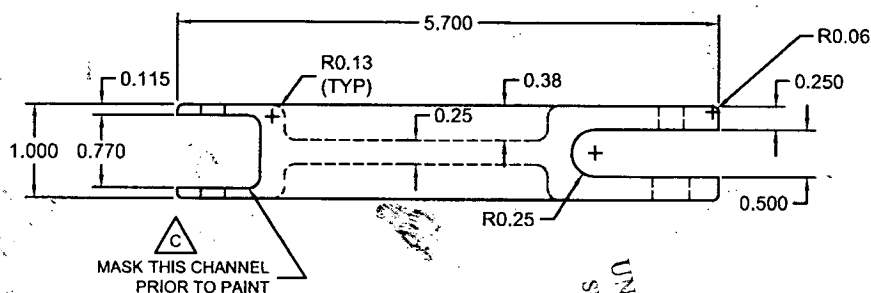
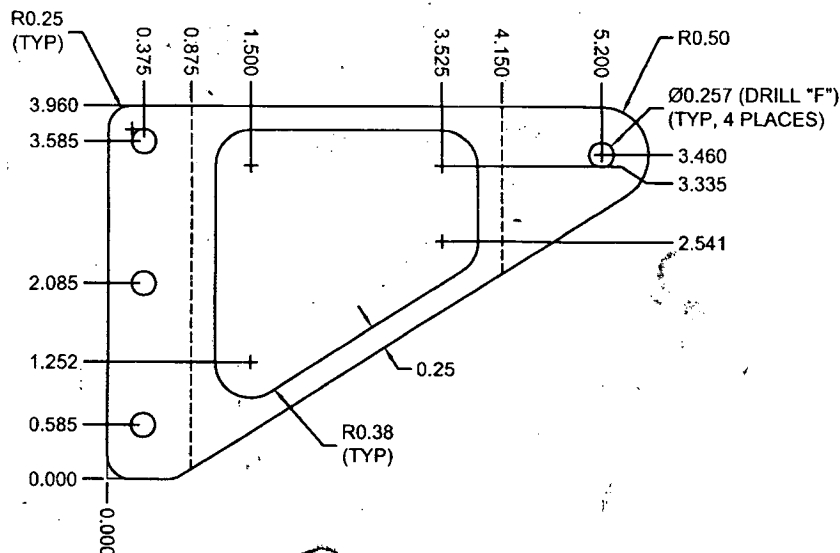
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED

07.08.29

D2499 MOUNT

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2499" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.65 lbs

C	- ADDED MASKING DETAIL - DUE TO TIGHT FIT WHEN INSTALLED ON BASKET - ADD MASKING STEP TO ESTIMATE	DC	07.07.25
B	CHANGE HOLE DIA TO .386	KH	95.12.06
A	NEW ISSUE	BW	95.11.09
REV.	DESCRIPTION	BY	DATE
DESIGN	B WILLIAMS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D2499	SHEET 1 OF 1
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	MOUNT	1:2
DATE	07.07.25	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order: 37543
Description: MOUNT		Part Number: D2499
Inspection Dwg: D2499 Rev: C		Page 1 of 1 Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.585	+/- .010	0.583	✓			
1.252	+/- .010	1.251	✓			
2.085	+/- .010	2.086	✓			
3.585	+/- .010	3.585	✓			
3.960	+/- .010	3.958	✓			
0.375	+/- .010	0.372	✓			
0.875	+/- .010	0.875	✓			
1.500	+/- .010	1.505	✓			
3.525	+/- .010	3.520	✓			
4.150	+/- .010	4.150	✓			
5.200	+/- .010	5.1985	✓			
3.460	+/- .010	3.468	✓			
3.335	+/- .010	3.335	✓			
2.541	+/- .010	2.541	✓			
0.25	+/- .030	0.2455	✓			
5.700	+/- .010	5.697	✓			
0.115	+/- .010	0.112	✓			
0.770	+/- .010	0.769	✓			
1.000	+/- .010	0.991	✓			
0.25	+/- .030	0.249	✓			
0.38	+/- .030	0.378	✓			
0.250	+/- .010	0.244	✓			
0.500	+/- .010	0.502	✓			

Measured by: BA / [Signature]
Date: 08/03/17

Audited by: [Signature]
Date: 08.03.17

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

